

Date: Thursday, 15/01/2009 12:36:39 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT ASSY (LH)
Job Number : 44850	
Estimate Number : 13285	
P.O. Number :	Part Number : D3699041
This Issue : 15/01/2009 S.O. No. :	Drawing Number : D3699 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 41019	Material :
Written By :	Due Date : 22/01/2009
Checked & Approved By : <u>Julie Dawson 01.15</u>	Qty : 5 Um : Each
Comment : Est Rev:A 08-04-25 new issue DD verified by:ec Est Rev:B 08-07-14 revA as per dwg DD verified by:ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S050	6061-T6 .050 Sheet
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Comment: Qty.: 0.4797 sf(s)/Unit Total : 1.9190 sf(s)
 6061T6 aluminium sheet .050" thick
 (M6061T6S050)
 Batch: 104186 B 9-1-19

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3699
 Dwg Rev: A B 9-1-19
 Prog Rev: A
 ***grain direction along 9.00" ***
 2- Deburr if necessary B 9-1-19

(5)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 02/01/19 (5)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Bend as per Dwg D3697

S 09/01/20 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 15/01/2009 12:36:39 PM
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Process Sheet

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Job Number: 44850

Part Number: D3699041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/01/20 (AS)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-counter sink holes as per dwg D3699

EP 09/01/21 (S)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/01/21 (ASLH)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AWM 9-1-23

(X4)

10.0

POWDER COATING

POWDER COATING



M 10 S 642



(5X4)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:20
OF
320
12:50

M-L 09/01/23

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

5 09/01/26 (ASLH)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

13.0

MS21059L3

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut Plate

batch:

M107394

SS 09/01/23 (X4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 15/01/2009 12:36:39 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSY (LH)

Job Number: 44850

Part Number: D3699041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10 8.0000 Each(s)
Rivet M1503

SS 09/01/23 (x4)

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg D3699

SS 09/01/26 (5)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SS 09/01/26 (x5)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST 184

SS 09/01/26 (x5)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SS 09/01/26 (x5)

Job Completion



mk 09-01-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: W4850
Description: Support, LH		Part Number: D3699-1
Inspection Dwg: D3699	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

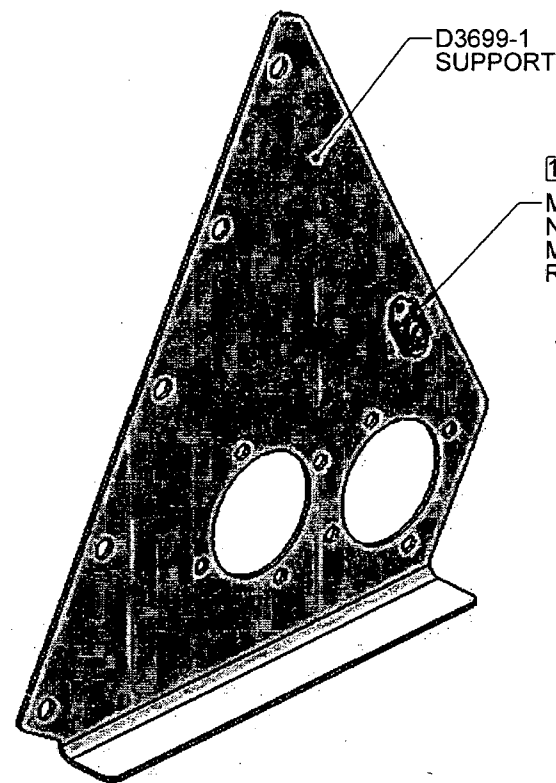
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.101	X			
Ø0.180	+0.005/-0.001	.184	X			
Ø0.238	+0.005/-0.001	.243	X			
Ø1.525	+0.012/-0.001	1.529	X			
0.36	+/-0.030	.363	X			
0.62	+/-0.030	.617	X			
0.96	+/-0.030	.966	X			
2.21	+/-0.030	2.215	X			
4.12	+/-0.030	4.114	X			
8.95	+/-0.030	8.948	X			
1.925	+/-0.010	1.920	X			
8.61	+/-0.030	8.606	X			
2.62	+/-0.030	2.625	X			
0.344	+/-0.010	.341	X			
0.688	+/-0.010	.688	X			
0.64	+/-0.030	.640	X			
2.66	+/-0.030	2.664	X			
5.75	+/-0.030	5.751	X			
6.41	+/-0.030	6.406	X			
0.300	+/-0.010	.301	X			
0.923	+/-0.010	.920	X			
0.050	+/-0.010	.048	X			

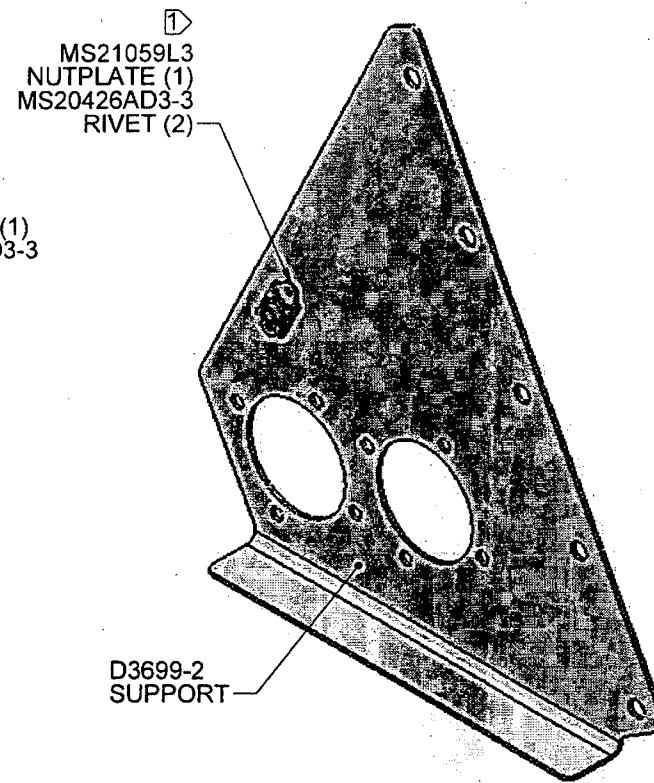
Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-1-19	Date: 09/01/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	DD

P/O D3699-041



D3699-041 SUPPORT ASSEMBLY



D3699-042 SUPPORT ASSEMBLY

PART LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3699-041	SUPPORT ASSEMBLY
	X	D3699-042	SUPPORT ASSEMBLY
1		D3699-1	SUPPORT
	1	D3699-2	SUPPORT
1	1	MS21059L3	NUTPLATE
2	2	MS20426AD3-3	RIVET

NOTES:

- 1) INSTALL MS21059L3 NUTPLATE USING C'SINK $\varnothing 0.098$ HOLES ON D3699-1/-2
- 2) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3699-041/-042 & B/N USING FINE POINT PERMANENT INK MARKER
- 3) WEIGHT: 0.17 lb EACH

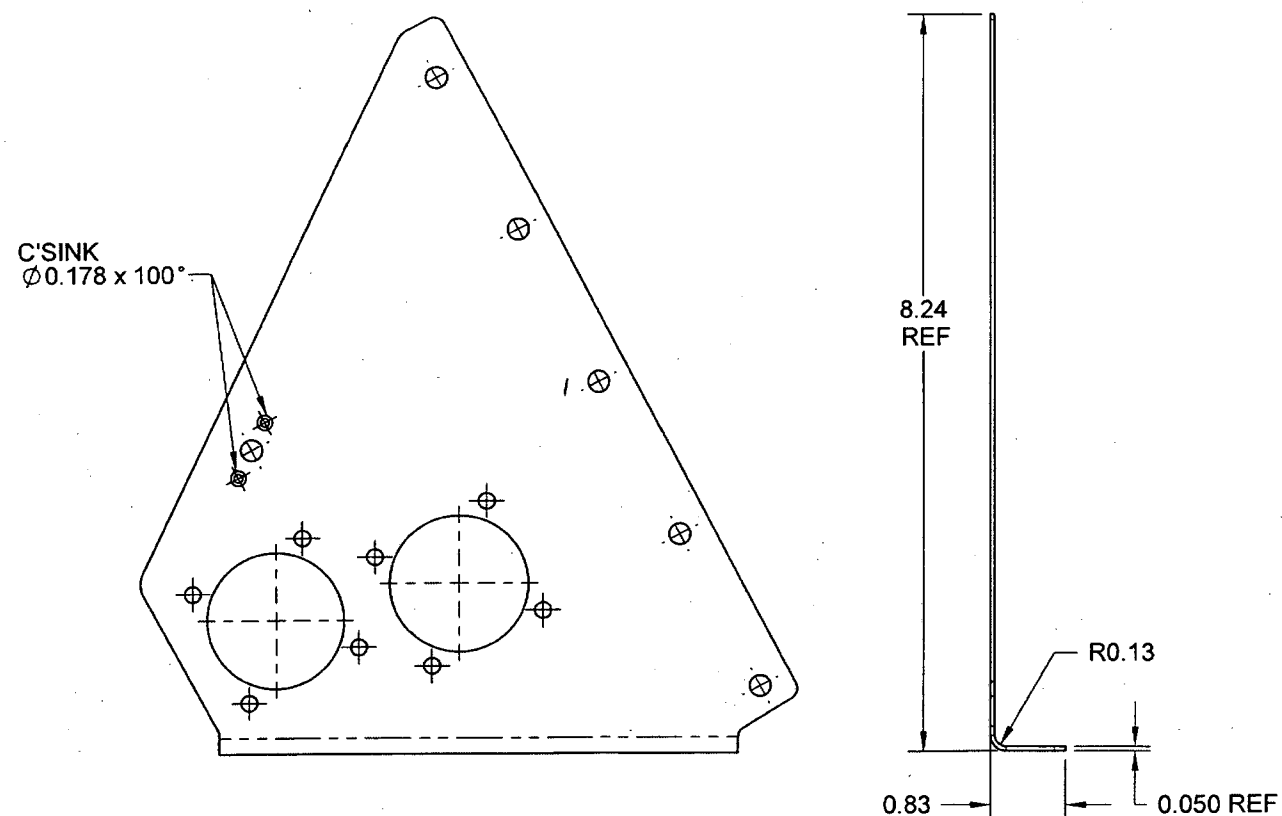
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CONTACT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44850

RELEASED
08.07.12

A	NEW ISSUE	RF	08.05.12
REV.	DESCRIPTION	BY	DATE
DESIGN	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	JP	D3699	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	SUPPORT ASSEMBLY	NTS
DATE	08.05.12	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

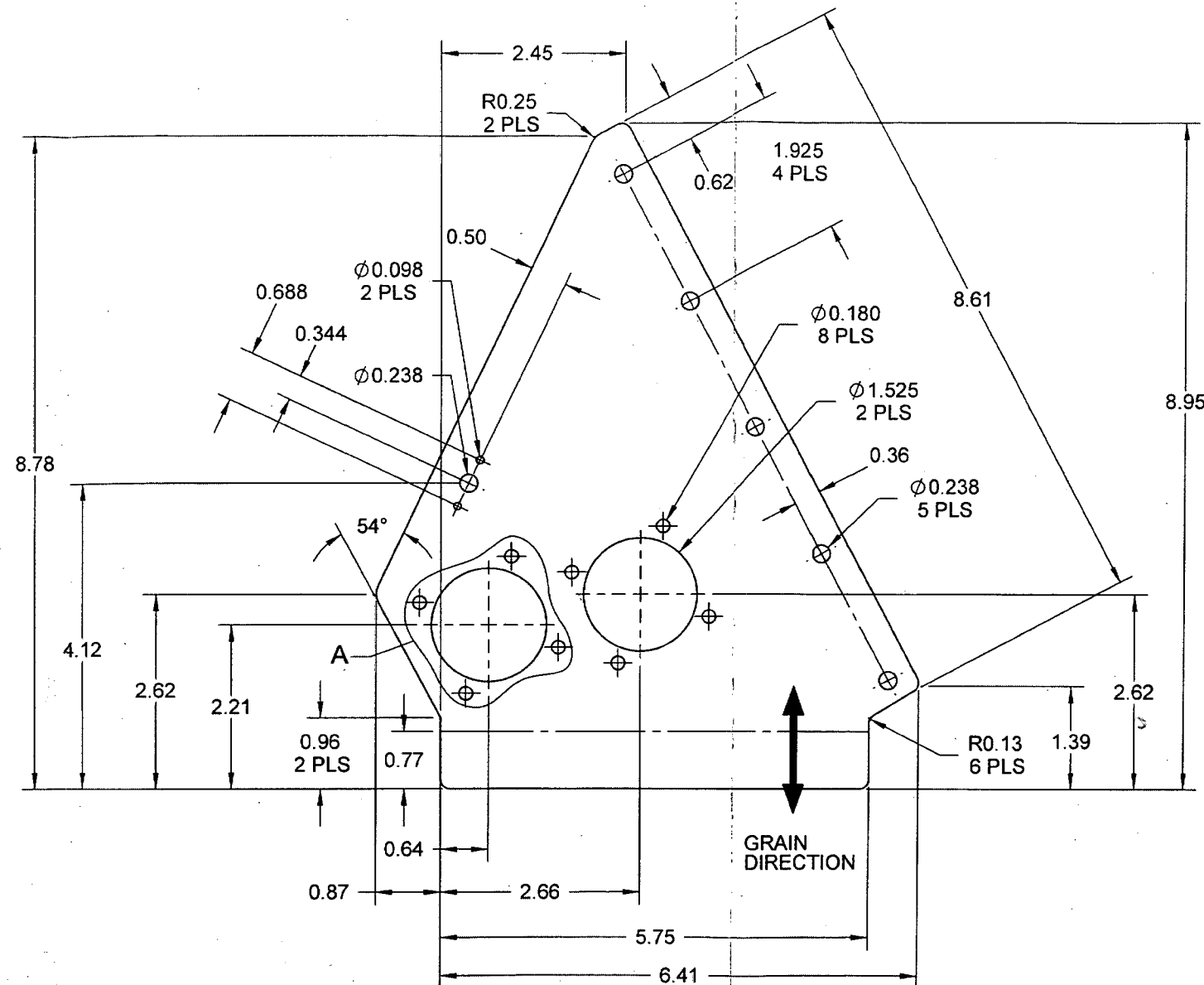
D3699-1 LH SUPPORT

D3699-2 RH SUPPORT

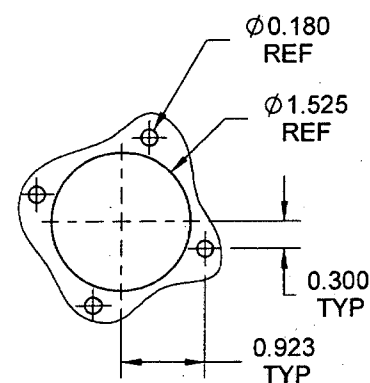


**D3699-1 SUPPORT, LH SHOWN
(D3699-2 SUPPORT, RH OPPOSITE)
(MAKE FROM D3699-1F FLAT PATTERN)**

- NOTES:
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK (REF. DART SPEC. M2024T3S.050 OR M6061T6S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.17 lbs



D3699-1F FLAT PATTERN




DETAIL A

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08-07-08
NO. 446840

DESIGN	RF,	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3699	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT ASSEMBLY	NTS
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